

## CLAIMS

I Claim:

1. A method of rolling lips about the open mouths of stacked thermoplastic containers, comprising the steps of:  
5 presenting a nested stack of containers having unrolled lips to a rim roller;  
engaging individual cups on a screw assembly;  
heating a supply of air in a heater to a desired temperature;  
discharging the supply of heated air toward the containers as they are engaged on the screw assembly; and  
10 rolling the lips of the containers in the screw assembly.

2. The method of Claim 1, further comprising the step of preventing the screw assembly from operating until the supply of air reaches the desired temperature.

15 3. The method of Claim 2, wherein the screw assembly includes a plurality of screw curlings.

4. The method of Claim 3, wherein the screw assembly includes three screw curlings.

20 5. The method of Claim 1, further comprising the step of passing the nested stack of containers under a crowd brush to direct the containers to the screw assembly.

6. The method of Claim 1, further comprising the step of moving the heater to a position proximate the nested stack of containers when the supply of air reaches the desired 25 temperature.

7. The method of Claim 1, further comprising the step of moving the heater to a position distant from the nested stack of containers in the event of a malfunction or stoppage.

30 8. The method of Claim 6, further comprising the step of moving the heater to a position distant from the nested stack of containers in the event of a malfunction or stoppage.

9. The method of Claim 6, wherein the step of moving the heater to a position proximate to the nested stack comprises the step of actuating a movable cylinder having the heater attached thereto.

5 10. The method of Claim 9, wherein the step of actuating comprises the step of sensing a desired temperature at a position proximate the nested stack of containers.

10 ~~N.~~ A method of rolling lips about the open mouths of stacked thermoplastic containers, comprising the steps of:

15 presenting a nested stack of containers having unrolled lips to a rim roller;  
engaging individual cups on a screw assembly;  
moving a heater to a position proximate the nested stack of containers when the heater reaches a desired temperature;  
heating the containers with the heater; and  
rolling the lips of the containers in the screw assembly.

20 12. The method of Claim 11, further comprising the step of moving the heater to a position distant from the nested stack of containers in the event of a malfunction or stoppage.

25 13. The method of Claim 11, wherein the step of moving the heater to a position proximate to the nested stack comprises the step of actuating a movable cylinder having the heater attached thereto.

14. The method of Claim 13, wherein the step of actuating comprises the step of sensing a desired temperature at a position proximate the nested stack of containers.

25 15. The method of Claim 14, wherein the heater is a forced air heater.

30 16. The method of Claim 15, wherein the step of heating comprises the step of discharging heated air at containers.

17. The method of Claim 16, wherein the step of discharging heated air is limited to an area of the nested stack of containers proximate the screw assembly.